

Work Order ID 55108

January 6, 2010 11:48:16 AM

Page 1

Item ID: D2807-041

Accept

Setup Start

Revision ID:

Item Name: Door prop

Stop

Start Date: 1/06/10 Start Qty: 20.00

Required Date: 1/20/10 Req'd Qty: 20.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 10/01/06 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2807

Rev E

100

0.00



Purchasing

Purchasing

PURCHASING

Memo

0.00

Issue P/O: 11045 ☐ Order as per Dwg D2807 ☐ Possible  
supplier: Lift Support Technologies, Saskatoon, Canada ☐ P/N 6/15-164/50-115N

☐  
Material release note is required

CL 10/01/06 20

110

0.00



Packaging

Packaging

Receive & Inspect for Damage & Mat'l Certs

Memo

0.00

Ensure Material Release Note is attached

10/01/12 (20)

120

0.00



QC

Quality Control

QC6- Inspect dimensions to drawing

Memo

0.00

All later at 33-35 lbs of force

⇒ S106119

counters  
(x20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 55108**

January 6, 2010 11:48:16 AM



Page 2

Item ID: D2807-041

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Start Date: 1/06/10

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Cust Item ID:

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Req'd Qty: 20.00



Customer:

Reference:

Run Start



Stop



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

I-install D3671-1 as per dwg D2807

*EB 10/01/27 (9)*

140

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

*⇒ 5.10.01.27**(X5)*

150

0.00



Packaging

Identify as per dwg & Stock Location: *25*

Memo

0.00

Packaging

*10-1-27 - (92) SL*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**Work Order ID 55108**

Page 3

January 6, 2010 11:48:16 AM

Item ID: D2807-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Door prop

Start Date: 1/06/10 Start Qty: 20.00



Cust Item ID:

Required Date: 1/20/10 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/27  
MF  
10-1-27

# Picklist Print

January 6, 2010 11:48:15 AM

Page 1

Work Order ID: 55108



Parent Item: D2807-041



Parent Item Name: Door prop





Start Date: 1/06/10

Required Date: 1/20/10

Comments:

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3671-1  Placard		Manufactured	No			110	Each	9.0000	20.0000 		<i>950 1/10/01/27</i>	
<div> <div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST</div> <div>50174</div> </div> <div> <div>Loc Qty</div> <div>9</div> <div>9</div> </div> <div> <div>Loc Code</div> <div></div> </div>												
6/15-164/50-115N  Gas Spring		Purchased	No			130	Each	0.0000	20.0000 		<i>9 1/10/01/27</i> <i>55108</i>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

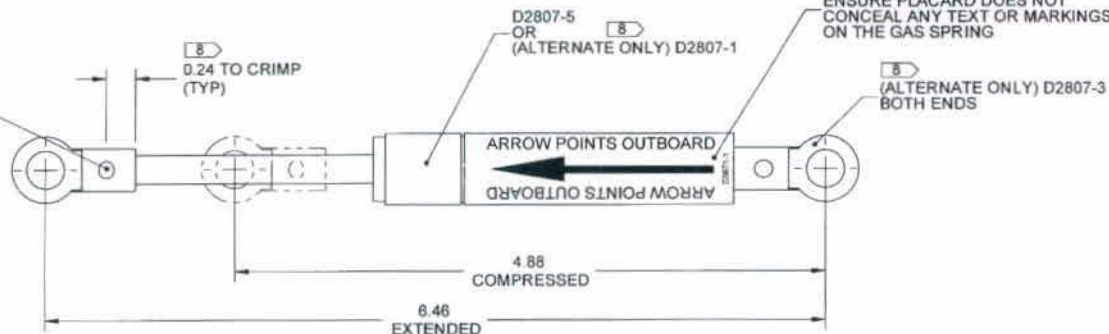
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# SPECIFICATION CONTROL DRAWING



(ALTERNATE ONLY)  
CRIMP 0.015-0.025 DEEP  
WITH  $\phi$  0.375 TOOL AT  
2000psi (REF), TYP TWO  
SIDES PER LUG



AFFIX D3671-1 PLACARD  
ENSURE PLACARD DOES NOT  
CONCEAL ANY TEXT OR MARKINGS  
ON THE GAS SPRING

(ALTERNATE ONLY) D2807-3  
BOTH ENDS

D2807-041 GAS SPRING

RELEASED  
08-12-11

## D2807-041 GAS SPRING ASSEMBLY PARTS LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D2807-041	GAS SPRING ASSEMBLY
1	D2807-5	GAS SPRING
1	D3671-1	PLACARD

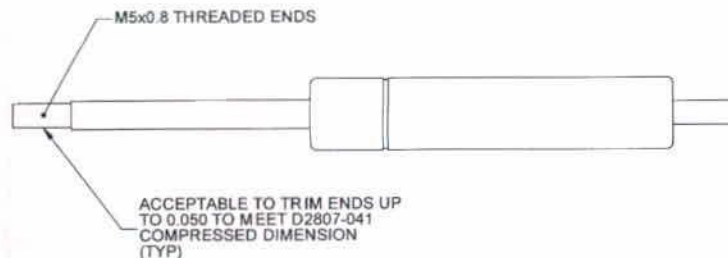
### NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.169 LBS
- 8) ALTERNATE PART: D2807-5 CAN BE MADE FROM ASSEMBLING D2807-1 (1) AND D2807-3 (2) (WEIGHT: 0.176 LBS)

C210101104  
W10:55108

E	ADD D2807-5 GAS SPRING; D2807-11-3 ASSEMBLY IS AN ALTERNATE TO D2807-5 GAS SPRING, UPDATE DIMENSIONS ON D2807-3	PH	07.12.28
D	ADDED D3671-1 PLACARD ADDED -041 ASSEMBLY UPDATED DWG	DC	07.09.27
C	CHANGE SPRING TO SS, ADD -3 LUG	CP	05.05.25
B	ADD FINISH	CP	05.03.16
A	NEW ISSUE	DS	00.11.03
REV.	DESCRIPTION	BY	DATE
DESIGN	44	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	44		
CHECKED	44		
MFG. APPR.	44		
APPROVED	44		
DE APPR.	44	DRAWING NO. REV. I	
DATE	07.12.28	D2807 SHEET 1 OF 1	
		TITLE SCALE	
		GAS SPRING NTS	
COPYRIGHT © 2000 BY DART AEROSPACE LTD			
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD			

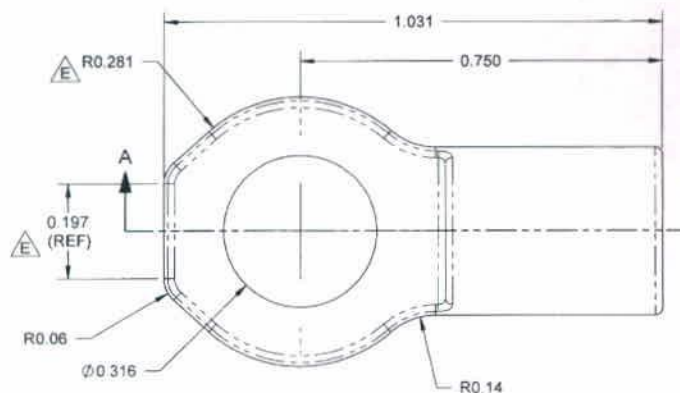
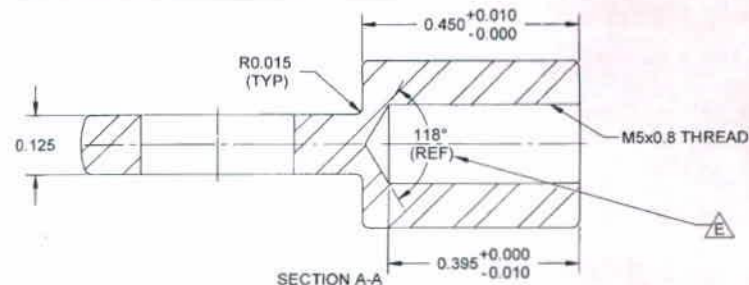




**D2807-1 GAS SPRING**  
SCALE 1:1

**D2807-1 GAS SPRING NOTES:**

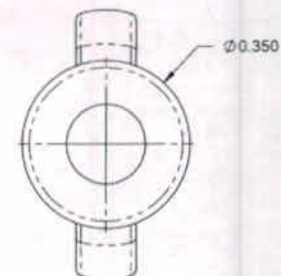
- 1) POSSIBLE SUPPLIER: ARVINMERITOR MOTION CONTROL SYSTEMS, LEICESTER, UK  
(PIN SXF6S6050080S6L-115N)  
(REF: 80MM LONG CYLINDER, 50MM STROKE, 115N LOAD)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.144 LBS
- 8) SPECIFICATION: SS GAS SPRING  
ACCEPTABLE LOAD RANGE IS 25 LB (115 N) MIN TO 45 LB (200 N) MAX  
M5x0.8 THREADS



**D2807-3 LUG**

**D2807-3 LUG NOTES:**

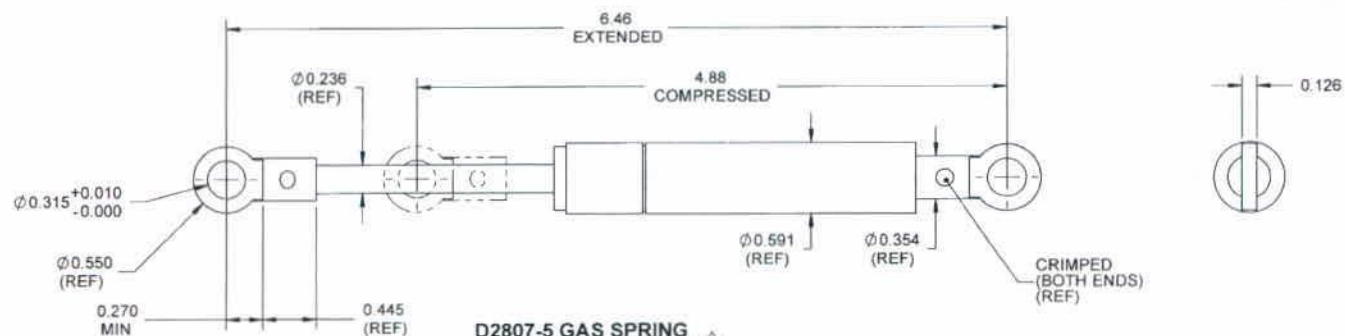
- 1) MATERIAL: AISI 303 ROUND BAR (REF. DART SPEC. M303R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.015
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.016 LBS



RELEASED

55708

DESIGN	#	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	#		
CHECKED	#	DRAWING NO. <b>D2807</b>	REV. E
MFG. APPR.	#	TITLE <b>GAS SPRING</b>	SHEET 2 OF 3
APPROVED	#	SCALE 4:1	
DE APPR.	#	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND UNCLASSIFIED AND IS SUPPLIED BY THE SERVICE PROVIDER THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	07.12.28		



**D2807-5 GAS SPRING**

**D2807-5 GAS SPRING NOTES:**

- 1) POSSIBLE SUPPLIER: LIFT SUPPORT TECHNOLOGIES, SASKATOON, CANADA  
(P/N 6/15-164/50-115N)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.169 LBS
- 8) SPECIFICATION: SS GAS SPRING WITH END FITTINGS,  
ACCEPTABLE LOAD RANGE 25 LB (115 N) MIN TO 45 LB (200 N) MAX.

DESIGN	PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED	HE	DRAWING NO <b>D2807</b>	REV. E
MFG. APPR.	HE	TITLE <b>GAS SPRING</b>	SHEET 3 OF 3
APPROVED	HE	SCALE 4:1	
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RELEASED

55108



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID PO11045

Purchase Order Date 1/06/10

PO Print Date 1/06/10

Page Number 1 of 1

Order From :

VC-LST0001

LS TECHNOLOGIES INC.  
303-103 STREET  
SASKATOON, SK S7N 1Y9  
CA

**FAXED**  
Circle

Contact Name  
Vendor Phone 306 683 5000  
Vendor Fax 306 683 6403  
Vendor Account Nbr

Buyer Chantal Lavoie  
Requisition Nbr  
Tax Resale Nbr 10127-2607  
Terms Net 30  
Currency CAD  
FOB

Ship To : DART AEROSPACE LTD 1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	6/15-164/50-115N	Gas Spring	1/20/10 Yes	20.00 Each	FedEx PI ppd	\$63.9000	\$1,278.0

Special Inst: AS PER DWG D2807 REV. E  
B55108  
LS TECHNOLOGIES P/N: 6/15-164/50-  
115N

PO Total: \$1,278.0

CERTIFICATE OF CONFORMITY  
REQ'D UPON DELIVERY

Change Nbr: 1

Change Date: 1/06/10

CL  
W  
No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required when applicable



303 - 103<sup>rd</sup> Street, Saskatoon, Saskatchewan, Canada S7N 1Y9  
Ph: (306) 683-5000 Fax: (306) 683-6403  
E-mail: [lstech@lsttechnologies.ca](mailto:lstech@lsttechnologies.ca) [www.liftsupporttechnologies.com](http://www.liftsupporttechnologies.com)

### Certificate of Compliance

This is to certify that the parts listed below meets specifications as required by your order.

20 Units: D2807 - 6/15-050-164-115N Stainless Gas Spring

Country of Manufacture: Canada

Date of Manufacture : Jan 2010

This product is ROHS compliant.

*S. Solberg*

We certify no mercury was used in the manufacture of this order.

Purchase Order # 11045

Invoice # 5650

L S Technologies Inc Canada

A handwritten signature in black ink, appearing to read "Nolan Fehr".

Nolan Fehr  
Manager